



# ROLF

ENGG. SOLUTIONS INC.



**Manufacturer & Exporters of**  
**High Tensile Carbon Steel, API 5L X52 to X70 PSL 1/2, LSAW, ERW & Seamless Pipes & Fittings,**  
**Stainless Steel, Alloy Steel Pipes & Fittings, High Nickel Alloys, Monel, Inconel, Hastelloy, SM0254,**  
**Duplex, Super Duplex, Titanium-B2, B5 - Pipes & Fittings, Finned Tubes, Studded Pipes.**



# Standard Specification for Welded Ferritic-Martensitic Stainless Steel Pipe<sup>1</sup>

This standard is issued under the fixed designation A 1053/A 1053M; the number immediately following the designation indicates the year of original adoption or, in the case of revision, the year of last revision. A number in parentheses indicates the year of last reapproval. A superscript epsilon ( $\epsilon$ ) indicates an editorial change since the last revision or reapproval.

## 1. Scope

1.1 This specification covers seam welded ferritic-martensitic (dual phase) stainless steel pipe intended for abrasive and general corrosion service. Nominal sizes are NPS 2 to NPS 36 inclusive, with nominal (average) wall thickness up to 0.75-in. (19 mm).

1.2 The values stated in either inch-pound units or SI units are to be regarded separately as standard. Within the text, the SI units are shown in brackets. The values stated in each system are not exact equivalents. Therefore each system must be used independently of the other. Combining values from the two systems may result in nonconformance with the specification. The inch-pound units shall apply unless the “M” designation is specified in the order.

1.3 *This standard does not purport to address all of the safety concerns, if any, associated with its use. It is the responsibility of the user of this standard to establish appropriate safety and health practices and determine the applicability of regulatory limitations prior to use.*

## 2. Referenced Documents

### 2.1 ASTM Standards:<sup>2</sup>

- A 370 Test Methods and Definitions for Mechanical Testing of Steel Products
- A 941 Terminology Relating to Steel, Stainless Steel, Related Alloys, and Ferroalloys
- A 999/A 999M Specification for General Requirements for Alloy and Stainless Steel Pipe
- A 1010/A 1010M Specification for Higher-Strength Martensitic Stainless Steel Plate, Sheet, and Strip
- A 1016/A 1016M Specification for General Requirements for Ferritic Alloy Steel, Austenitic Alloy Steel, and Stainless Steel Tubes
- E 527 Practice for Numbering Metals and Alloys (UNS)

### 2.2 ANSI/ASME Standards:<sup>3</sup>

- B1.20.1 Pipe Threads, General Purpose
- B36.10 Welded and Seamless Wrought Steel Pipe
- B36.19 Stainless Steel Pipe

### 2.3 Other Standard:

- SAE J1086 Practice for Numbering Metals and Alloys (UNS)<sup>4</sup>

## 3. Terminology

### 3.1 Definitions:

- 3.1.1 The definitions in Specification A 999/A 999M and Terminology A 941 are applicable to this specification.

## 4. Ordering Information

- 4.1 Orders for material to this specification shall conform to the requirements of the current edition of Specification A 999/A 999M.

## 5. General Requirements

- 5.1 Material furnished under this specification shall conform to the applicable requirements of the current edition of Specification A 999/A 999M unless otherwise provided herein.

## 6. Materials and Manufacture

### 6.1 Material:

- 6.1.1 The material for this pipe shall conform to Specification A 1010/A 1010M Grade 50 dual phase stainless steel.

### 6.2 Manufacture:

- 6.2.1 The pipe shall be made using Electric Resistance Welding (ERW) or an automatic fusion welding process with no addition of filler metal during the welding process.

- 6.2.2 Welded pipe of NPS 14 and smaller shall have a single longitudinal weld. Welded pipe of a size larger than NPS 14 shall have a single longitudinal weld or shall be produced by forming and welding two longitudinal sections of flat stock when approved by the purchaser. All weld tests, examinations, inspections or treatments shall be performed on each weld seam.

- 6.2.3 The pipe shall be free of scale and contaminating surface iron particles. Pickling, blasting or surface finishing is

<sup>1</sup> This test method is under the jurisdiction of ASTM Committee A01 on Steel, Stainless Steel and Related Alloys and is the direct responsibility of Subcommittee A01.10 on Stainless and Alloy Steel Tubular Products.

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<sup>2</sup> For referenced ASTM standards, visit the ASTM website, [www.astm.org](http://www.astm.org), or contact ASTM Customer Service at [service@astm.org](mailto:service@astm.org). For *Annual Book of ASTM Standards* volume information, refer to the standard's Document Summary page on the ASTM website.

<sup>3</sup> Available from American National Standards Institute (ANSI), 25 W. 43rd St., 4th Floor, New York, NY 10036, <http://www.ansi.org>.

<sup>4</sup> Available from Society of Automotive Engineers (SAE), 400 Commonwealth Dr., Warrendale, PA 15096-0001, <http://www.sae.org>.

not mandatory. The purchaser is permitted to require that a passivating treatment be applied to the finished pipe.

6.3 *Heat Treatment*—All pipe shall be made from heat-treated strip or plate, cold formed and welded. The weld may be induction strip tempered, at the discretion of the buyer, at a minimum temperature of 1300 °F [700 °C], but not exceeding 1400 °F [760 °C].

## 7. Chemical Composition

7.1 The steel shall conform to the requirements as to chemical composition as prescribed in [Table 1](#).

## 8. Product Analysis

8.1 At the request of the purchaser, an analysis of one length of flat rolled stock from each heat, or two pipes from each *lot*, shall be made by the manufacturer. A *lot* of pipe shall consist of the following number of lengths of the same size and wall thickness from any one heat of steel:

NPS Designator	Lengths of Pipe in <i>Lot</i>
Under 2	400 or fraction thereof
2 to 5	200 or fraction thereof
6 and over	100 or fraction thereof

8.2 The results of these analyses shall be reported to the purchaser or the purchaser’s representative, and shall conform to the requirements of [Section 7](#).

8.3 If the analysis of one of the tests specified in [8.1](#) does not conform to the requirements specified in [Section 7](#), an analysis of each pipe from the same heat or *lot* may be made, and all pipes conforming to the requirements shall be accepted.

## 9. Permitted Variations in Wall Thickness and Diameter

9.1 The wall thickness of the pipe shall be within the tolerances specified in [Table 2](#), except that the weld area shall not be limited by the “Over” tolerance.

9.2 The outside diameter to be used for inspection for compliance with this requirement when ordered by NPS and schedule number is shown in [Table 3](#). Other diameters and wall thicknesses may be used when specified in the purchase order. Standard sizes of NPS pipe are listed in [Table 4](#).

## 10. Tensile Requirements

10.1 The tensile properties of the pipe shall conform to the requirements prescribed in [Table 5](#).

## 11. Mechanical Tests Required

11.1 *Mechanical Testing Lot Definition*—The term *lot* for mechanical tests shall be as follows:

11.1.1 The *lot* size shall be that defined in [8.1](#).

11.1.2 The minimum number of tests shall be one (1) test per *lot*.

11.2 *Transverse or Longitudinal Tension Test*—One tension test shall be made on a specimen for *lots* of not more than 100 pipes. Tension tests shall be made on specimens from two tubes for *lots* of more than 100 pipes.

11.3 *Flattening Test*—Flattening tests shall be made on a sufficient number of pipes to constitute 1 % of the *lot*, but at least one length of pipe. Flattening tests shall be made on specimens from two tubes for *lots* of more than 100 pipes.

11.4 A transverse guided face bend test may be conducted instead of a flattening test in accordance with the method outlined in the steel tubular product supplement of Test Methods and Definitions [A 370](#). The ductility of the weld shall be considered acceptable when there is no evidence of cracks in the weld or between the weld and the base metal after bending. Test specimens from 1 % of the *lot* shall be taken from the pipe or test plates of the same material as the pipe, the test plates being attached to the end of the cylinder and welded as a prolongation of the pipe longitudinal seam.

## 12. Hydrostatic or Nondestructive Electric Test

12.1 Each pipe shall be subjected to a nondestructive electric test or hydrostatic test. The type of test to be used shall be at the option of the manufacturer, unless otherwise specified in the purchase order.

12.2 The hydrostatic test shall be in accordance with Specification [A 999/A 999M](#), unless specifically exempted under the provisions of [12.3](#).

12.3 For pipe whose dimensions equal or exceed NPS 10, the purchaser, with the agreement of the manufacturer, is permitted to waive the hydrostatic test requirement when in lieu of such test the purchaser performs a system test. Each length of pipe furnished without the completed manufacturer’s hydrostatic test shall include with the mandatory marking the letters “NH.”

12.4 The nondestructive electric test shall be in accordance with Specification [A 999/A 999M](#).

## 13. Lengths

13.1 Pipe lengths shall be in accordance with the following practice:

13.1.1 The standard length, unless otherwise agreed upon, shall be 20 ft [6 m] with the permitted range of 17 to 24 ft [5.2 to 7.3 m]. Shorter lengths are acceptable, but the number and minimum length shall be agreed upon between the manufacturer and the purchaser.

13.1.2 For slurry applications, to minimize turbulence at the jointers, the continuous length is 50 ft [15.2 m] with a permitted range of 48 to 54 ft [14.6 to 16.5 m].

13.1.3 If definite cut lengths are desired, the lengths required shall be specified in the order. No pipe shall be under the specified length and no pipe shall be more than ¼ in. [6 mm] over the specified length.

13.1.4 No jointers are permitted unless otherwise specified and agreed upon between the purchaser and manufacturer.

## 14. Workmanship, Finish, and Appearance

14.1 The finished pipes shall be straight within # 0.2 % of length of pipe using a taught wire the length of the pipe.

14.2 The finished pipes shall have a workmanlike finish. Removal of imperfections by grinding is permitted, providing the wall thickness is not decreased to less than that permitted in [Section 9](#) of Specification [A 999/A 999M](#).

## 15. Repair by Welding

15.1 For welded pipe whose diameter  $\geq$  NPS 4, and whose nominal wall thickness  $\geq$  0.188 in. [4.77 mm], it is permitted to make weld repairs with the addition of compatible filler

**TABLE 1 Chemical Composition Requirements, %<sup>A</sup>**

UNS Designation <sup>B</sup>	Carbon	Manganese	Phosphorous	Sulfur	Silicon	Chromium	Nickel	Nitrogen	Other Elements
S41003	0.030	1.50	0.040	0.030	1.00	10.5–12.5	1.50	0.030	...

<sup>A</sup>Maximum, unless range or minimum is indicated.

<sup>B</sup>Designation established in accordance with Practice E 527 and SAE J 1086.

**TABLE 2 Permitted Variations in Wall Thickness**

NPS Designator (All t/D ratios)	Tolerance, % from Nominal	
	Over	Under
Up to 2 ½ incl.	20	12.5
3 to 18 incl.	22.5	12.5
20 and larger	15.0	12.5

**TABLE 3 Permitted Variations in Outside Diameter**

NPS Designator	Over	Under
2 through 18	1 %	1 %
20 and over	0.75 %	0.75 %

metal to the weld seam or parent metal when approved by the purchaser. Repair welding shall meet the requirements of Specification A 999/A 999M.

15.2 The composition of the deposited filler metal shall be suitable for the Specification A 1010/A 1010M ferritic-martensitic plate.

15.3 Pipes that have had weld seam repairs with filler metal shall be identified in the stencil with “WR” and shall be so identified on the certificate of tests.

## 16. Certification

16.1 In addition to the information required by Specification A 999/A 999M, the certified mill test report (CMTR) shall state whether or not the material was hydrostatically tested. If the material was nondestructively tested, the certification shall so state and shall state which practice was followed and what reference discontinuities were used.

## 17. Marking

17.1 In addition to the marking specified in Specification A 999/A 999M, the marking shall include the NPS (nominal

pipe size) or outside diameter, the schedule number or average or minimum wall thickness, specification number, alloy grade, heat number, NH when hydrostatic testing is not performed and ET or UT when eddy current or ultrasonic testing is performed. If the seam weld is x-rayed, the line marking shall so state. The markings also shall include the manufacturer’s private identifying mark, and the marking required by 15.3, if applicable. If specified in the purchase order, the marking for pipe larger than NPS 4 shall include the weight per foot [weight per metre].

## 18. Government Procurement

18.1 Scale Free for Government Procurement:

18.1.1 When specified in the contract or order, the following requirements shall be considered in the inquiry, contract or order, for agencies of the U.S. Government where scale free pipe or tube is required. These requirements shall take precedence if there is a conflict between these requirements and the product specifications.

18.1.2 The requirements of Specification A 999/A 999M for pipe and Specification A 1016/A 1016M for tubes shall be applicable when pipe or tube is ordered to this specification.

18.1.3 *Ordering Information*—Orders for material under this specification shall include the following in addition to the requirements of Section 4:

18.1.3.1 Pipe or tube,

18.1.3.2 Part Number,

18.1.3.3 Ultrasonic inspection if required,

18.1.3.4 If shear wave is to be conducted in two opposite circumferential directions, and

18.1.3.5 Level of preservation and packing required.

## 19. Keywords

19.1 dual phase; ferritic-martensitic stainless steel; stainless steel pipe; steel pipe; welded steel pipe

**TABLE 4 Dimensions of Welded Pipe**

NPS Designator	Outside Diameter		Nominal Wall Thickness							
			Schedule 5S <sup>A</sup>		Schedule 10S <sup>A</sup>		Schedule 40S and Standard		Schedule 80S and Extra Heavy	
	in.	mm	in.	mm	in.	mm	in.	mm	in.	mm
2	2.375	60.33	0.065	1.65	0.109	2.77	0.154	3.91	0.218	5.54
2 ½	2.875	73.03	0.083	2.11	0.120	3.05	0.203	5.16	0.276	7.01
3	3.500	88.90	0.083	2.11	0.120	3.05	0.216	5.49	0.300	7.62
3 ½	4.000	101.60	0.083	2.11	0.120	3.05	0.226	5.74	0.318	8.08
4	4.500	114.30	0.083	2.11	0.120	3.05	0.237	6.02	0.337	8.56
5	5.563	141.30	0.109	2.77	0.134	3.40	0.258	6.55	0.375	9.52
6	6.625	168.28	0.109	2.77	0.134	3.40	0.280	7.11	0.432	10.97
8	8.625	219.08	0.109	2.77	0.148	3.76	0.322	8.18	0.500	12.70
10	10.750	273.05	0.134	3.40	0.165	4.19	0.365	9.27	0.500 <sup>B</sup>	12.70 <sup>B</sup>
12	12.750	323.85	0.156	3.96	0.180	4.57	0.375 <sup>B</sup>	9.52 <sup>B</sup>	0.500 <sup>B</sup>	12.75 <sup>B</sup>
14	14.000	355.60	0.156	3.96	0.188 <sup>B</sup>	4.78 <sup>B</sup>	...	...	...	...
16	16.000	406.40	0.165	4.19	0.188 <sup>B</sup>	4.78 <sup>B</sup>	...	...	...	...
18	18.000	457.20	0.165	4.19	0.188 <sup>B</sup>	4.78 <sup>B</sup>	...	...	...	...
20	20.000	508.00	0.188	4.78	0.218 <sup>B</sup>	5.54 <sup>B</sup>	...	...	...	...
22	22.000	558.80	0.188	4.78	0.218 <sup>B</sup>	5.54 <sup>B</sup>	...	...	...	...
24	24.000	609.60	0.218	5.54	0.250	6.35	...	...	...	...
30	30.000	762.000	0.250	6.35	0.312	7.92	...	...	...	...
32	32.000	812.80	...	...	0.312 <sup>C</sup>	7.92 <sup>C</sup>	...	...	...	...
34	34.000	863.60	...	...	0.312 <sup>C</sup>	7.92 <sup>C</sup>	...	...	...	...
36	36.000	914.40	...	...	0.312 <sup>C</sup>	7.92 <sup>C</sup>	...	...	...	...

<sup>A</sup>Schedules 5S and 10S wall thicknesses do not permit threading in accordance with ANSI B1.20.1.

<sup>B</sup>These do not conform to ANSI/ASME B36.10.

<sup>C</sup>These sizes are not included in ANSI/ASME B36.19.

**TABLE 5 Mechanical Test Requirements**

Grade	Yield Strength, min, ksi [MPa]	Tensile Strength, min, ksi [MPa]	Elongation in 2 in. [50 mm], min, %	Brinell Hardness, max
50	50 [350]	70 [485]	18	360

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